

Work Order ID 56880

March 12, 2010 9:57:36 AM



Page 1

Item ID: D3704-3

Accept



Setup Start



Revision ID:

Item Name: Escutcheon

Stop



Start Date: 3/12/10 Start Qty: 6.00



Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 6.00



Customer:

Reference:

DJF 10-03-12

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description
--------------------------------	--------------------------

Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

100



Bandsaw

Jaspa Bandsaw

Memo

CUT 3.00" LONG

0.00

DJP 10/03/22 6 φ

110



HAAS I

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA807
DWG REV: B
FOLIO REV: AA

DEBURR

0.00

DJP 10/03/22

MW 10/03/23

6

2

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3704-3 PAR #: Fault Category: machinery NCR: Yes No DQA: J Date: 063-30
 Resolution: SCV14 Disposition: scrap QA: N/C Closed: J Date: 10/03/31

NCR: 56880		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/03/22	100	Step 100 on W/o Say's to cut blank at 3.00" long ↳ Need to be 3.25" as on folio	J OSIUM	Scrap 1 part Change Route to 3.250 R.C.: I.P.P.	DJP 10/03/22 Jnd/00as-2 X 1003-30	J 1003-30	J OSIUM	J 1003-30
10/03/22	110	Had wrong End Mill in T11 R.C: L02	J OSIUM2	Scrap 1 part	DJP 10/03/22 Jnd/00as-2 X 1003-30	J 1003-30	J OSIUM	J 1003-30

NOTE: Date & initial all entries

Work Order ID 56880

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Page 2

Item ID: D3704-3

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Setup

Start



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Start Date: 3/12/10 Start Qty: 6.00



Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

DSP

Draw
Number

MW

Rev.

10/03/23

Draw
Rev.

Plan
Code

6

Accept
Qty

Z

Reject
Qty

2

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

Jew

10/03/23

6

2

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

10/03/24

0.00

X6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56880

March 12, 2010 9:57:37 AM



Page 3

Item ID: D3704-3

Accept



Setup



Revision ID:

Stop



Item Name: Escutcheon

Start Date: 3/12/10 Start Qty: 6.00



Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run



QC:

Date:

SPC (Y/N):

Date:

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

160



Packaging

Packaging

Identify as per dwg & Stock Location: 089

0.00

Memo

0.00

10/03/24 E

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/24 H

100-3-24
6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

March 12, 2010 9:57:35 AM

Work Order ID: 56880



Parent Item: D3704-3



Parent Item Name: Escutcheon

Start Date: 3/12/10

Required Date: 3/19/10

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased		No		f		52.8210	1.5600			

6061-T6 Bar 1.50 x 1.25



Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

52.8209921

107461

11.84

110936

40.9809921

1.5600

DJP 10/03/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

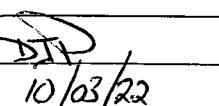
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

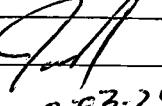
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:
Description: Escutcheon		Part Number: D3704-3
Inspection Dwg: D3704	Rev: B	Page 1 of 1

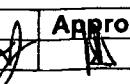
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension		Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.22	+/-0.030	1.222	✓			
0.610	+/-0.010	0.610	✓			
Ø0.170	+0.005/-0.001	0.171	✓			
Ø0.322 x 100°	+/-0.010 x +/-0.5°	0.330 x 100°	✓			
1.063	+/-0.010	1.063	✓			
2.125	+/-0.010	2.125	✓			
1.054	+/-0.010	1.053	✓			
0.206	+/-0.010	0.206	✓			
Ø0.440	+0.005/-0.001	0.441	✓			
0.90	+/-0.030	0.907	✓			
0.500	+/-0.010	0.510	✓			
0.125	+/-0.010	0.130	✓			
R0.06	+/-0.030	0.06	✓			
0.625	+/-0.010	0.625	✓			
R0.156	+/-0.010	0.156	✓			
R0.03	+/-0.030	0.030	✓			
0.03 x 45°	+/-0.030 x +/-0.5°	0.03x45°	✓			
Ø0.755	0.005/-0.001	0.755	✓			
0.175	+/-0.010	0.175	✓			
0.218	+/-0.010	0.218	✓			
0.435	+/-0.010	0.436	✓			
0.220	+/-0.010	0.220	✓			
0.06 x 45°	+/-0.030 x +/-0.5°	0.065x45°	✓			
Ø0.686	0.008/-0.001	0.685	✓			
Ø0.628	0.008/-0.001	0.628	✓			
0.685	+/-0.010	0.685	✓			

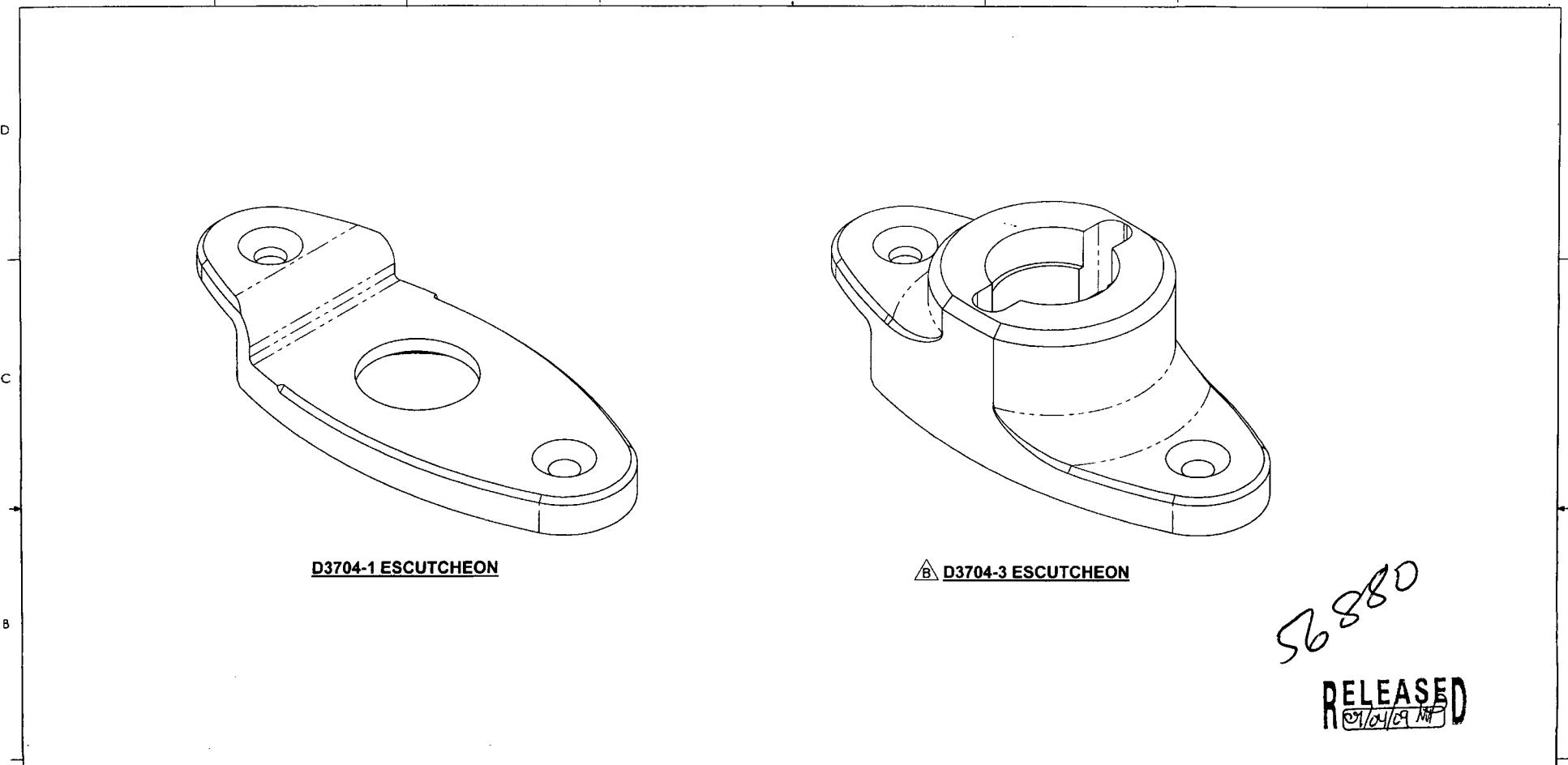
Measured by: 
Date: 10/03/22

Audited by: 
Date: 10-03-22

Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
A	10.02.02	New Issue	KJ	

8 7 6 5 4 3 2 1



D3704-1 ESCUTCHEON

A D3704-3 ESCUTCHEON

RELEASED
01/04/09 M

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3704-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D3704-1 = 0.04 lbs
 - D3704-3 = 0.11 lbs

8 7 6 5 4 3 2 1

B	ADDED D3704-3. REASON: COMPATIBILITY WITH AAI'S HANDLE	MB	09.03.17
A	NEW ISSUE	MB	08.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD		
DRAWN	HAWKESBURY, ONTARIO, CANADA		
CHECKED	REV. B		
MFG. APPR.	DRAWING NO. D3704		
APPROVED	TITLE SCALE		
DE APPR.	NTS		
DATE	ESCUTCHEON		
09.03.17			

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8 7 6 5 4 3 2 1

8

7

6

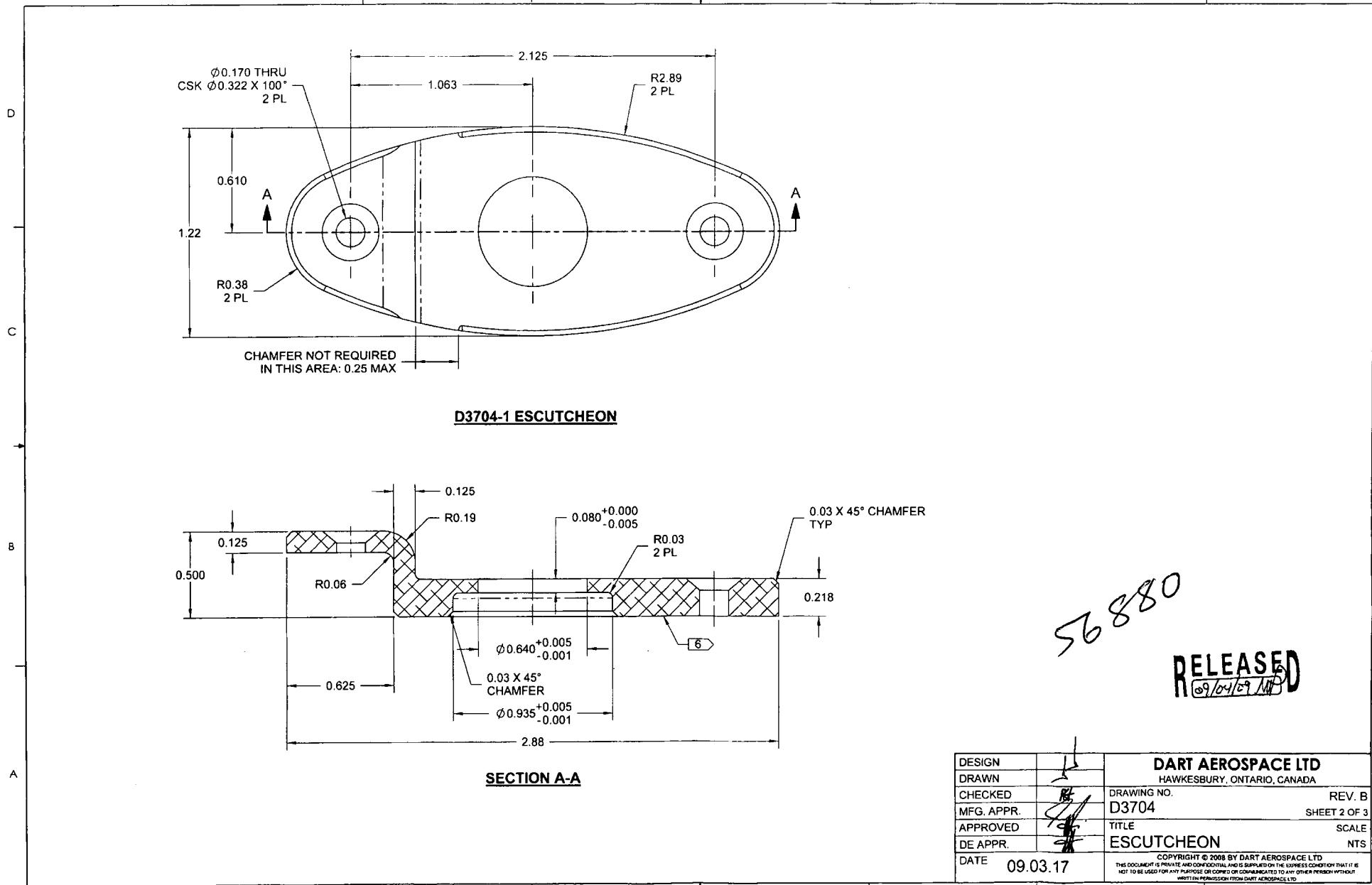
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4

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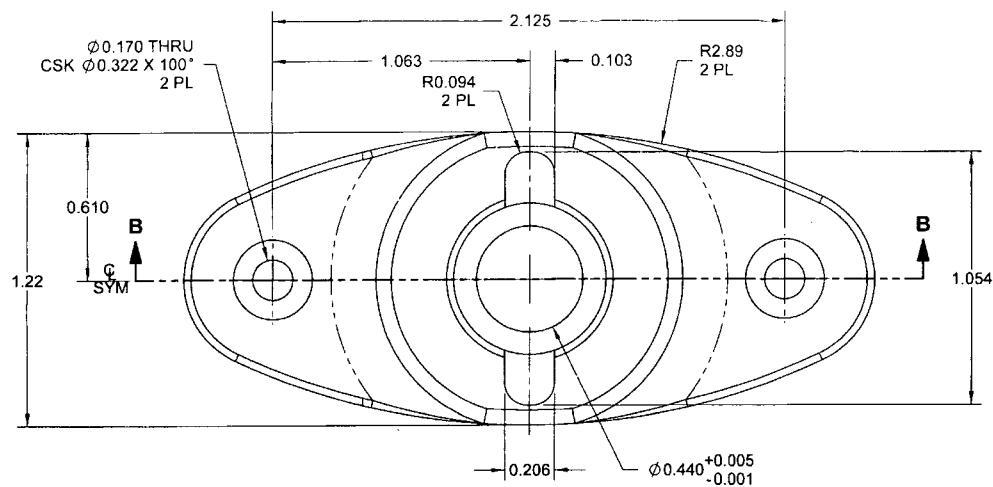
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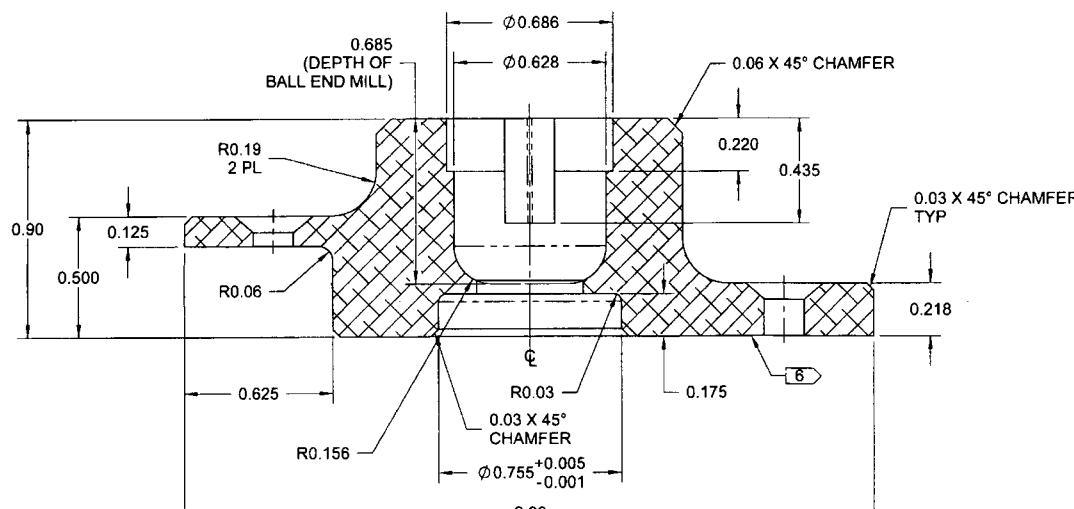
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2

1



D3704-3 ESCUTCHEON



SECTION B-B

56880

RELEASED
09/04/17 M

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. B
MFG. APPR.		DRAWING NO. D3704
APPROVED		SHEET 3 OF 3
DE APPR.		TITLE ESCUTCHEON
DATE	09.03.17	SCALE NTS

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